Work Orde April-22-13 1:4			148-041	*100	1462*						Page 1	
Item ID: Revision ID: Item Name:	D4148-041 Crosstube Lug		100462	Accept	*N900	<b>040</b>	100	<b>)*</b> s	Setup Start Stop	1 7	S1* S2*	
Start Date: Required Date: Reference:	4/22/13	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item I Customer:	D:						
Approvals:		*	Date: /3-04- ZS			ate:		F	Run Start Stop	1/1	R1* R2*	
Sequence ID/ Work Center II		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
Draw Nbr		ision Nbr										
D4148 100 *100* Small Fab Small Fab	D	Memo 1- Assemble	e as per dwg	0.00				6t	\	/	<b>J</b> S3/	67/10
110 * 1 1 0* QC Quality Control		QC5- Inspect part comp	leteness to step on W/O	0.00 S. 7/0	)	,		۵				
*120 *120* Packaging Packaging		Identify as per dwg & Si	tock Location	0.00				(ox			SP 13-7	(D

NCR: Y	es /	NO .		-	WORK ORDER NON-C	COr	VFORI	VIANCE / UPI		QA Closed:	Date:	
Work Orde	ır.				DISPOSITION				AGAINȘT DE	PARTMENT/	/PROCESS	
Part N	lo				Rework Scrap Use-as-is Work Order Update	Scrap Machining Small Fab Proc Use-as-is Thermoforming Finishing Rec/Store						Engineering Quality Other
Root	-	1		Descri	ption of work order update		nitial	Act	tion	Sign &		
Cause	Da	te Step	Qty	<u> </u>	or Non-conformance	Ch	ief Eng	Desci	ription	Date	Verification	QC Inspector
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Equip/Tooling						1						
Operator	_		Ì			1						
Material												
Setup	_											
Other			-			1						
Process	_											
Supplier	_											
Training				ļ								
Unapproved				<u> </u>		<u> </u>	T CATE	CORY				,
المسطان	C				r General	AUI	I CATE	GURT		<del></del>		
Landii	n <b>g Gear</b> Bend	ling '		Г	Bend	Г	Grain			Ovalized		Pressure/Forced
	_	re Not Conc	entric to		BOM/Route	$\vdash$	Hardwa	ire	<u></u>	Over/Under	tolerance	Temperature/Cure
	Crac		entric to	"  -	Broken/Damaged	$\vdash$	4	ion Incomplete	<u> </u>	Part Incorred	<u> </u>	Weld
		hed/Crimpe	d	-	Burrs	$\vdash$	4 '	ions Incomplete/	Unclear	Part Lost/Mi	<del></del>	Wrong Stock Pulled
	Cuff	-	<b>-</b>	-	Contamination	$\vdash$	Mainte	-		Part Moved		]
	Heat Treat Countersink					$\vdash$	Mislabe		<del>                                     </del>	Positioned V	Vrong	
	Inspection Strip in Tube Cut Too Short						Misrea			Power Loss/		Other
	Ripples in Bend Drill Holes						Offset			•		. <del>.</del>
	Torque Waves in Extrusion Drawing						Out of	Calibration				
	⊢	ing Sequenc			Finish		Out of	Sequence				

Outside Dimensions

DQA:

Date:

Wave/Twist in Tube

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Orde April-22-13 1:4		00462	alin kalenda <u>alin</u> a dan menada at m	*100	1462*		1				Pag	ge 2
Item ID: Revision ID: Item Name:	D4148-041 Crosstube Lu	g Assembly, Fwd		Accept	*N900	<b>040</b>	100	)* s	Setup Sta	ı	VS1*	
Start Date: 4/22/13 Required Date: 5/03/13 Reference:		Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item I Customer:	D:						
Approvals:	Process Pl	an:	Date:	Tooling: SPC (Y/N):		ate:	<u> </u>	R	tun Sta Sto	``'	NR1 <sup>,</sup> NR2 <sup>,</sup>	
Sequence ID/ Work Center II	<b>D</b>	Operation Description QC21- Final Inspection	- Work Order Release	Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Rejec Numl	_ •	)
*130*		Memo		0.00					19	17/11	4/	_

Quality Control

13/7/11 9

										DQA:	Date	•
NCR: Y	es / No				WORK ORDER NON-C	ON	IFORM	MANCE / UPD	ATE	04 61	Data	_
			······································			r				QA Closed:	Date	:
Morle Orde					DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Work Orde	HT:			<del></del>	Rework	1		Skid-tube	Crosstube		Water Jet	Engineering
Part N	io				Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
		-		<del></del>	Use-as-is			noforming	Finishing		e/Packaging	Other
NCR N	lo.				Work Order Update			Large Fab	Composite	,	Supplier	1   1
											-	
Root				Descri	ption of work order update	1	nitial	Acti	on	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Descri	ption	Date	Verification	QC Inspector
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Other												
Process								<u></u>			1	
Supplier	_					l						
Training												
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					<del></del>	AUL	T CATE	GORY				
Landi	ng Gear				General		ا ما			ا برا	Г	7
	Bending Bend Centre Not Concentric to O/S BOM/Route					$\vdash$	Grain			Ovalized	<u> </u>	Pressure/Forced
	<b>├</b> ── <b>│</b>						Hardwa		<del> </del>	Over/Under	<del>-</del>	Temperature/Cure
	Cracks Broken/Damaged						1	ion Incomplete		Part Incorred	<del>-</del>	Weld
	Crushed/Crimped Burrs						ł .	tions Incomplete/U	nciear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs	_		<b> </b>	Contamination		Mainte		<u> </u>	Part Moved	16	
	Heat Treat Countersink						Mislabe	eled		Positioned V	vrong	

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Other

Power Loss/Surge

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

Folio

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## Picklist Print April-22-13 1:40:58 PM Work Order ID: 1004 Parent Item: D41 Parent Item Name: Cros Comments: IPP IPP DD Component Item ID/ Reference Name Item Name

100462 D4148-041

D4148-041 Start Date: 4/22/13
Crosstube Lug Assembly, Fwd Start Qty: 6.00

t Qty: 6.00 Required Qty: 6.00

Required Date: 5/03/13

Page 1

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC

IPP Rev:B 10.07.22 as per revB DD verf:JLM IPP Rev:C 10.10.29 as per revC DD verf:EC IPP REV:D 11.03.02 AS PER DWG REV.D DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS21043-3 Nut		Purchased	No		····	100	Each	2,388.0000	4	12	Bi,	3/0,	7/0
				Location		Loc Qty	<u>L</u> e	oc Code					
				FG		80						,	
				103	3691	80							
				GA		106							
				123	3899	106							
				ST315		2202							
					3899	196				<del>`</del>	0	/	,
				124	4555	2006		100.000		<del></del>		1	/ /
<b>MS21043-4</b> Nut		Purchased	No			100	Each	439.0000	1	18	Lh.,	3/1	57/1
· vuc				<b>Location</b>		Loc Qty	<u>L</u>	oc Code					
				FG		36				/	•		
				104	4603	36							
				GA		44							
				12	1652	44							011
				ST315		359					Μ	125	807
				. 12	1162	25					<i>x</i> (		
					3021	303						()	8x)
				12	3525	29						( '	

123900

NCR: Y	'es / N	0			WORK ORDER NON-C	CON	<b>VFORI</b>	MANCE / UP	DATE			
· · · · · · · · · · · · · · · · · · ·		· 						•	· · · · · · · · · · · · · · · · · · ·	QA Closed:	Date:	
Work Orde	er:				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
					Rework	1 1		Skid-tube	Crosstube		Water Jet	Engineering
Part N	lo				Scrap		1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is		Thern	noforming	Finishing	Rec/Stor	re/Packaging	Other
NCR N	lo			· · · · · · · · · · · · · · · · · · ·	Work Order Update			Large Fab	Composite		Supplier	] []
Root				Descri	ption of work order update	l i	nitial	Ac	tion	Sign &		
Cause	Da	e Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling						1						
Operator										}		
Material										} •		
Setup		İ										
Other _			Ì									
Process						ĺ						
Supplier Training	$\vdash$											
Unapproved						1						
Ollappioved	<u> </u>				F	AUL	T CATE	GORY		(		<u></u>
Landii	ng Gear				General				<u>.</u>			
	Bend	ng		Γ	Bend		Grain			Ovalized		Pressure/Forced
	Centi	e Not Conce	entric to	o/s	BOM/Route		Hardwa	are		Over/Under	tolerance	Temperature/Cure
	Crack	s			Broken/Damaged		Inspect	ion Incomplete		Part Incorre	ct	Weld
	Crush	Crushed/Crimped Burrs					instruct	tions Incomplete/	'Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs Contamination						Mainte	enance		Part Moved		
	Heat Treat Countersink						Mislabe	eled		Positioned V	Vrong	<b>-</b>
	Inspection Strip in Tube Cut Too Short						Misrea	d		Power Loss/	Surge	Other
	Ripples in Bend Drill Holes					Offset						
	Torque Waves in Extrusion				Drawing	Ŀ	Out of	Calibration				
	Turni	ng Sequenc	e		Finish		Out of	Sequence				

Outside Dimensions

DQA:

Date:

Wave/Twist in Tube

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

April-22-13 1:40:59 PM

Work Order ID:	100462						Date: 4/22/13	D
Parent Item:	D4148-041							Required Date: 5/03/13
Parent Item Name:	Crosstube Lug Assembly, Fwd		•				<b>Qty:</b> 6.00	Required Qty: 6.00
22690-6 Lanyard Assembly	Manufactured	No	,	100	Each	33.0000	1	6 63/07
		Loca	tion	Loc Oty		Loc Code		
		ST01	4	33				R101075
			94775	9				
			95935	1			·	- B/01751
			98482	3				_ 2/2///
			99056	10		· ·	<del> </del>	<del></del>
			99808	10				- ///
rosstube Lug	Manufactured	No		100	Each	8.0000	1	6 2/30/0
		Loca	<u>ıtion</u>	Loc Qty		Loc Code		
		ST46	54	8				- / @ 16021
			81474	2				_ D/0039
			89772	1				_ `_
			93755	5				- ////
4091-1	Manufactured	No		100	Each	21.0000	1	6////
ounting Lug	4							
	•	Loca	<u>ıtion</u>	Loc Qty		Loc Code		
	-	ST14		21				1 13/00340
			97517	21		• • • • • • • • • • • • • • • • • • • •		
4148-1	Manufactured	No		100	Each	6.0000	2	
rosstube Lug Plate, Fw								12/3/07
rossiane Dag i late, i w	•	Las	<u>ıtion</u>	Loc Oty		Loc Code		
						Loc Coue		
		ST14		6				- B100297
			85753	2				_
94148-3		<b>N</b> T	97907	4	г. 1	14.0000		- 0/ /
	Manufactured	No		100	Each	14.0000	ı	6 // // 7
tud Receiver, Lower							<u></u>	400
		1 ·	<u>ation</u>	Loc Qty		Loc Code		
		STI	45	. 14				- B100534
			97610	. 8				$\mu_{1}$
9			97611	6				

									DQA:	Date:	age
NCR: Y	es / No				WORK ORDER NON-C	ONFOR	MANCE / UP		QA Closed:	Date:	
Work Orde	r:		ï		DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part N	Rework Skid-tube Crosstub  Scrap Machining Small Fa  Use-as-is Thermoforming Finishin  Work Order Update Large Fab Composit							Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	Initial	Ac	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling											
Operator		1									
Material						ļ ·					
Setup						Ì					
Other	7										
Process											

## **Landing Gear** General Bend Grain Ovalized Pressure/Forced Bending BOM/Route Over/Under tolerance Temperature/Cure Centre Not Concentric to O/S Hardware Part Incorrect Cracks Broken/Damaged Inspection Incomplete Weld Wrong Stock Pulled Part Lost/Missing Crushed/Crimped Burrs Instructions Incomplete/Unclear Part Moved Cuffs Contamination Maintenance Positioned Wrong Mislabeled Heat Treat Countersink Power Loss/Surge Other Inspection Strip in Tube Misread Cut Too Short **Drill Holes** Ripples in Bend Offset Torque Waves in Extrusion Drawing Out of Calibration Turning Sequence Finish Out of Sequence Wave/Twist in Tube Folio Outside Dimensions

**FAULT CATEGORY** 

Supplier Training Unapproved April-22-13 1:40:59 PM

Work Order ID:	100462									
Parent Item:	D4148-041							Start	Date: 4/22/13	Required Date: 5/03/13
Parent Item Name:	Crosstube Lug Asser	mbly, Fwd						Star	rt Qty: 6.00	Required Of: 6.00
D4148-5 Eyebolt Stud		Manufactured	No			100	Each	13.0000	1	6 53/07/10
				Location		Loc Qty		Loc Code		
				ST145		13				B/02/12 60
					97587	1				0102112
					99176	12				
AN3C12A		Purchased	No			100	Each	208.0000	2 1	2 67/10
Bolts									<del>- , , , </del>	
				<b>Location</b>		Loc Qty		Loc Code		
				ST351		208				•
					123648	5				
					124561	201				2 ( )
					124858	2				
AN4C13A		Purchased	No			100	Each	128.0000	3 1	8
BOLT										JS13/07/10
				Location		Loc Qty		Loc Code		
				ST356		3			- <u></u>	
					123900	3				4
				ST514		123				/1125+05/9)
					124805	123				M125709 (9) M126 193 (9)
				ST516		2				M126 193(01)
					124215	2				
MS17984-C413		Purchased	No			100	Each	15.0000	1	6 / - / - /
PIN, QUICK RELEASE									Gallery and American	C) 13/07/10
				Location		Loc Qty		Loc Code		
				ST332		2				101125877
					118612	2				125827
				ST508		13				$(C_{\mathcal{X}})$
				2.500	124231	13				42
										•

												DQA:	Dat	te:	
NCR: Y	'es	/ No				<b>WORK ORDER NON-C</b>	O	NFORM	MANCE / UP	DATE		_	_		
			,								С	QA Closed:	Dat	te:	
Mork Ords	٠					DISPOSITION				AGAINST D	EP#	ARTMENT/	PROCESS		
Work Orde	er: -		-:			Rework	1		Skid-tube	Crosstube	٦		Water Jet	$\neg$	Engineering
Part N	10	_	*			Scrap			Machining	Small Fab	-	Proc	d. Eng. Coor.	-	Quality
Partin	10.					Use-as-is			noforming	Finishing	+		e/Packaging	$\dashv$	Other
NCR N	J۵		`,		•	Work Order Update		1116111	Large Fab	Composite	1	rice, stor	Supplier	-	
I CIT I	•0					Work order opdate	'		20.80.00				- Cappilla		
Root					Descri	ption of work order update	1	nitial	Ac	tion	Τ	Sign &			
Cause		Date	Step	Qty	(	or Non-conformance	Ch	ief Eng	Desc	ription		Date	Verification	n	QC Inspector
Doc/Data							l								
Equip/Tooling			:		 						ı				
Operator							1				١				
Material							ļ				ŀ				
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Other		-	]												
Process									·						
Supplier			1												
Training			1		İ		ĺ							İ	
Unapproved										<u>.</u>	$\perp$				
						F	AUL	T CATE	GORY						
Landi	ng G	Gear				General				_	_		ı		•
		Bending				Bend	L	Grain			_ (	Ovalized			Pressure/Forced
Centre Not Concentric to O/S					o/s	BOM/Route		Hardwa	ire	_	<u>ا</u> ر	Over/Under	tolerance		Temperature/Cure
		Cracks				Broken/Damaged		Inspect	ion Incomplete		┥.	Part Incorrec		_	Weld
	Crushed/Crimped Burrs							Instruct	tions Incomplete/	'Unclear	P	Part Lost/Mi	ssing	L	Wrong Stock Pulled

Maintenance

Out of Calibration
Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Part Moved

Positioned Wrong

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cuffs

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

April-22-13 1:40:59 PM

Work Order ID:	100462							Staut D	Pate: 4/22/13		Required Date: 5/03/13
Parent Item:	D4148-041	5 1									Required Qty: 6.00
Parent Item Name:	Crosstube Lug As	sembly, Fwa							<b>Qty:</b> 6.00		Required Qty: 0.00
MS20615-4M18 Rivet		Purchased	No			100	Each	219.0000	8	48	JS13/07
				Location	<u>n</u>	Loc Qty		Loc Code			
				GA		7			4		11 0-1
					122452	7					19125654
				ST312		212					11/10
					124331	115					. ( 90%
					125162	97				<del></del>	11
NAS1149C0332R		Purchased	No			100	Each	7,451.0000	4	24	//(1/27
Washer		•							erman me anne e		JUD 107
				<u>Locatio</u>	<u>n</u>	Loc Qty		Loc Code			
				FP001		264				/	
					123355	264					
		- w <sub>i</sub> ,		ST292		4309					
		1		f	123248	18			~~~	<del></del>	
	•				123759 🗕	2801			_2	<del>/</del>	
					125268	1490				<u> </u>	
				ST517		2878					
					124580	- 2878			•	<del></del>	
NAS1149C0432R		Purchased	No			100	Each	1,686.0000	6	36	1/(2/12/
Washer		•									- J-1-1-1-1-1-1-1-1-1-1-1-1-1-1-1-1-1-1-
				Locatio	<u>n</u>	Loc Oty		Loc Code		_	
				ST292		1686				/	
					119124	6					III. AGAT
					122441	1680				<del></del>	M125867
											1110
											(36x)

NCR: Y	es / No				WORK ORDER NON-	COL	VFORM	MANCE / UP	DATE			
	<del> </del>									QA Closed:	Dat	e:
Work Orde	eř:				DISPOSITION	-	: :		AGAINST DE	PARTMENT	-	
Part N					Rework Scrap Use-as-is Work Order Update		1	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
Root	-	Ţ	T	Descri	ption of work order update		nitial	Act	tion	Sign &		
Cause	Date	Step	Qty	1	or Non-conformance	1	ief Eng	l	ription	Date	Verification	QC Inspector
Doc/Data								<u> </u>				
Equip/Tooling												
Operator												
Material						1						
Setup												
Other			ľ									
Process												
Supplier									•			
Training		:										
Unapproved									•			
					F	AUL	T CATE	GORY				
Landir	ng Gear				General							
	Bendin	3			Bend		Grain			Ovalized		Pressure/Forced
	Centre	Not Conce	ntric to	o/s	BOM/Route		Hardwa	ire		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged		Inspecti	ion Incomplete		Part Incorre	it [	Weld
	Crushed/Crimped				Burrs		instruct	tions Incomplete/	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination	Г	Mainte	enance		Part Moved	_	
	Heat Treat Count				Countersink		Mislabe	eled		Positioned V	Vrong	
	Inspect	ion Strip ir	1 Tube		Cut Too Short		Misread	d		Power Loss/	Surge [	Other
	Ripples	in Bend			Drill Holes		Offset					
	Torque	Waves in	Extrusio	on 🗀	Drawing		Out of 0	Calibration				

Out of Sequence

Outside Dimensions

DQA:

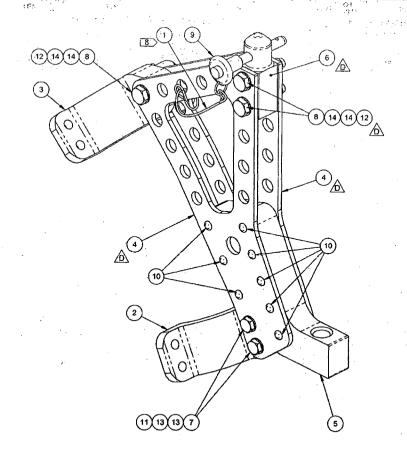
Date:

Turning Sequence

Wave/Twist in Tube

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G



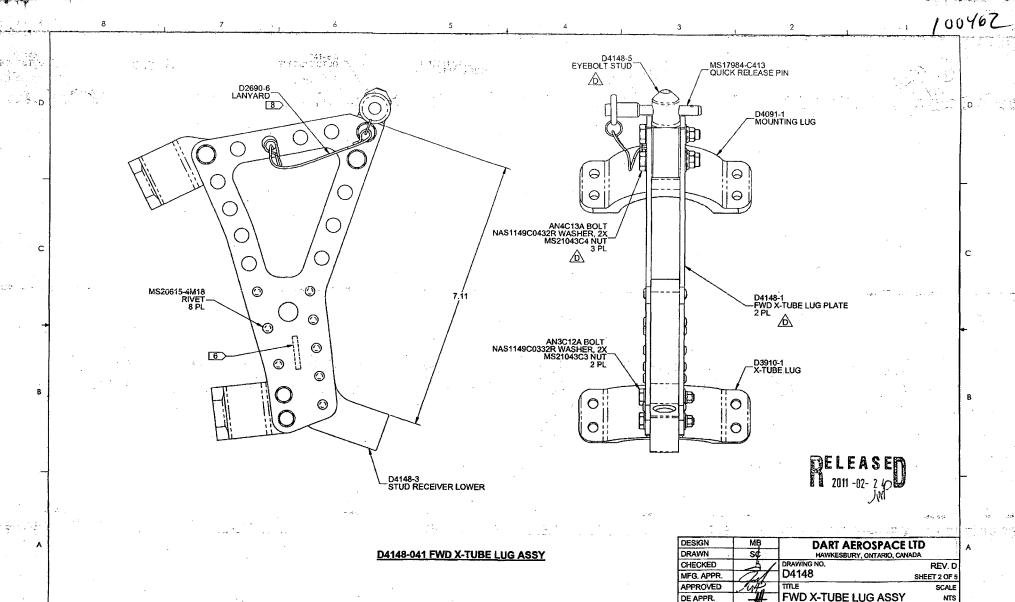
NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4148-041" PER DART QSI 044 6.1
7) WEIGHT: 3.67 lbs
8) ATTACH D2690-6 TO D4148-1 BY LOOPING AROUND A LIGHTENING HOLE FIRST AND THEN SECURE TO MS17984-C413

	ITEM	QTY -041	P/N ~	DESCRIPTION
		X	D4148-041	FWD X-TUBE LUG ASSY
	1	1	D2690-6	LANYARD
	2	1	D3910-1	X-TUBE LUG
	3	1	D4091-1	MOUNTING LUG
Γ	4	2	D4148-1	FWD X-TUBE LUG PLATE
'	5	1	D4148-3	STUD RECEIVER LOWER
<u> </u>	6	1	D4148-5	EYEBOLT STUD :
1				4
1	7	2	AN3C12A	BOLT
	8	3	AN4C13A	BOLT
<u> </u>	9	1	MS17984-C413	PIP PIN
	10	8	MS20615-4M18	RIVET
İ	11	2	MS21043C3	NUT
-	12	3	MS21043C4	NUT
1	13	4	NAS1149C0332R	WASHER
L	14	6	NAS1149C0432R	WASHER

100462 MUS 13-04-25

	·		
D	HOLE DIA CHANGED TO 0.252" (DB-3): MOLE DIA CHANGED TO 0.250" (CB-5): REPLACED QTY(2) AN3C12A, MS21043C3 AND QTY(4) NAS1149C0332R WITH QTY(2) AN4C13A, MS21043C4 AND QTY(4) NAS1149C0432R (D3-1,C4-2)	sc	11.02.22
С	REDESIGNED D4148-1/-3 TO ADDRESS COMPATIBILITY ISSUES WITH D350-591 SHORT STEPS	мв	10,10.12
В	REPLACED CITY(3) MS20615-4M16 WITH CITY(2) EACH AN3C12A, MS21403-3 AND CITY(4) NAS1149C0332R WASHER (ZN D3-1, B7-2 & B4-2); MS20615-4M18 WAS MS20615-4M20 (ZN D3-1, & B7-2); Ø0.1912 Pt, REPLACES Ø0.129 7P, (ZN D6-3); Ø0.129 7P, UMS-10 Pt, (ZN A7-3); Ø0.191 WAS 0.126 (ZN C&-S). REASON: SEE TR-0350-607-2 REV. B.	мв	10.07.05
A	NEW ISSUE	MB .	10.06.18
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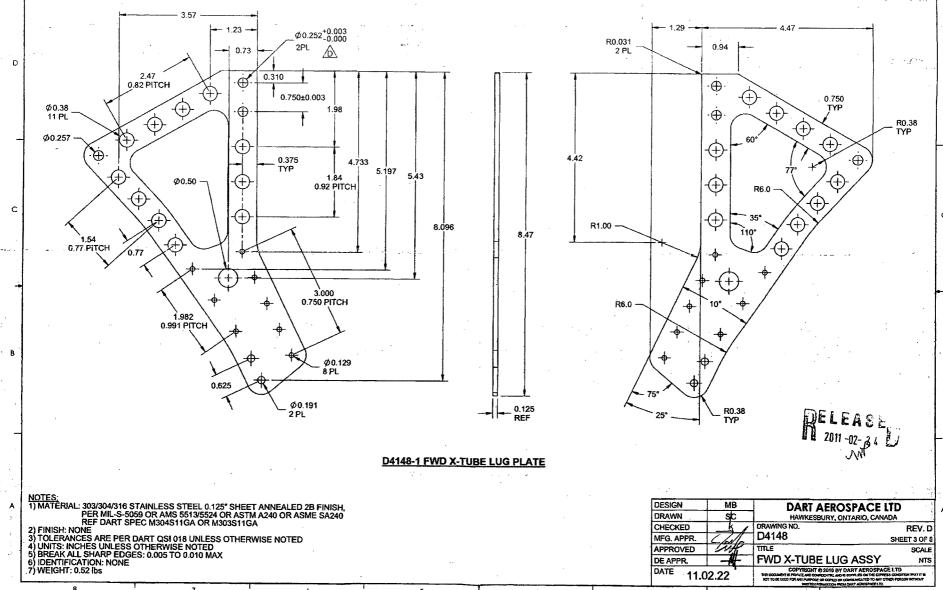
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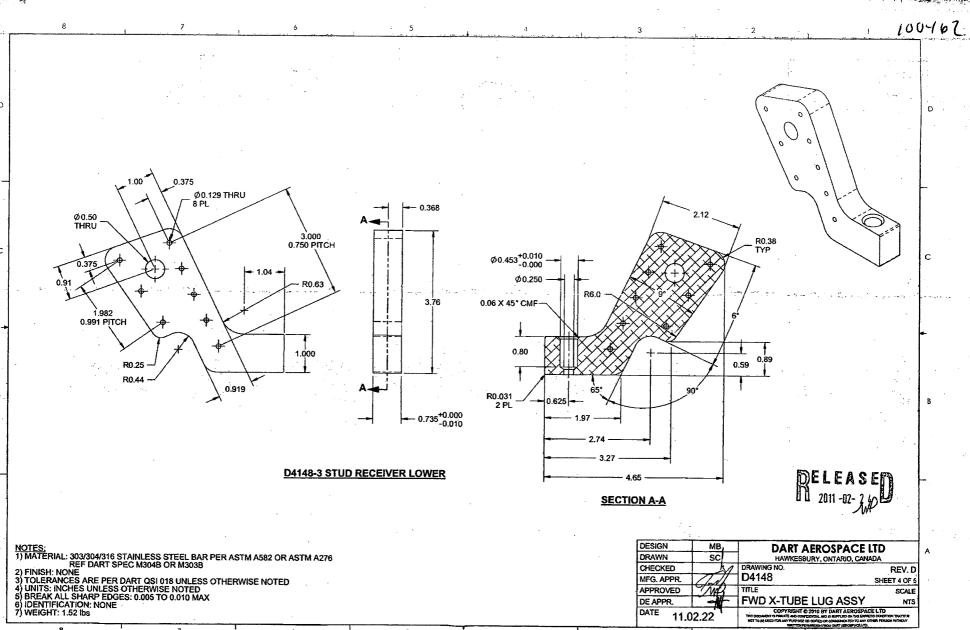


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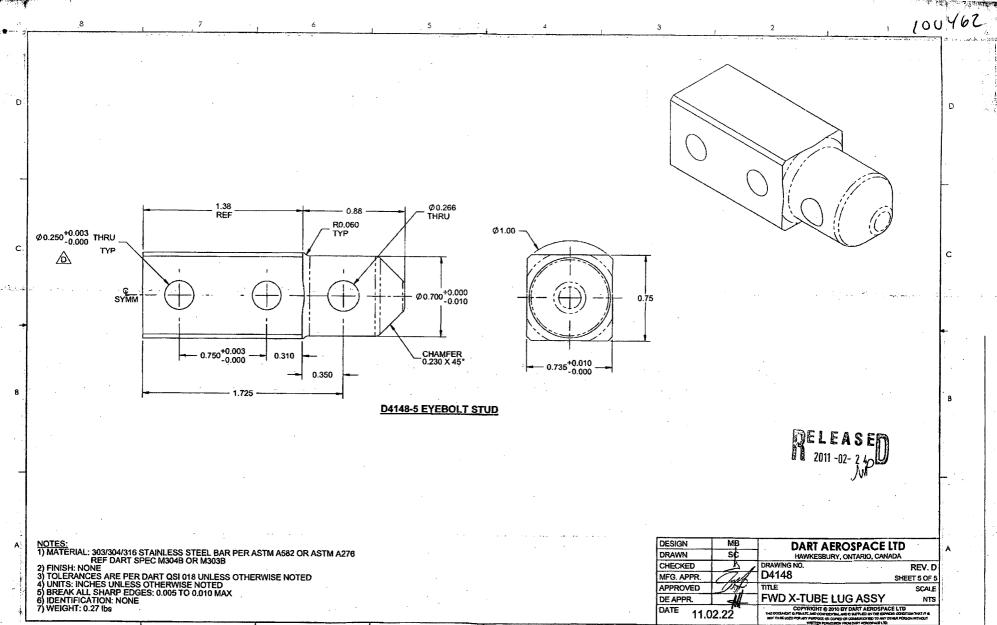
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